

Work Order ID 144125

144125

Page 1

April 04, 2016 3:11:37 PM

Item ID: D4038-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Angle Assy Fwd LH
 Start Date: 4/20/2016 Start Qty: 1.00
 Required Date: 5/24/2016 Req'd Qty: 1.00
 Reference: Cust Item ID:
 Customer:

Approvals: Process Plan: SHA Date: 20160405 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
100									
100	Pick Kit	0.00							
Packaging	Memo	0.00							
Packaging									
110									
110		0.00							
Small Fab	Memo	0.00							
Small Fab	Assemble as per dwg								
120									
120	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									

121

122

M 131631
Powder coat white as per dwg
*** Mask holes with no bolts and mask interior*
*of blocks ***
QC 3

START: 10:10
OV. T: 320°
FINISH: 10:40

2 *16-05-25*

DAS
38
9-88
MAY 17 2016

DAS
38
9-88
MAY 25 2016

2 *38*
9-88

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval	
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

Work Order ID 144125

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144125

Page 2

Item ID: D4038-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Angle Assy Fwd LH
 Start Date: 4/20/2016 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 5/24/2016 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

Identify as per dwg & Stock Location: **SKH**

0.00

130

Packaging

Memo

0.00

Packaging

**DMS
6
9-29**

MAY 25 2016

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

16/5/26

MLS

MAY 26 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
		OTHER : ☐			

Picklist Print

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Page 1

Work Order ID: 144125

144125

Parent Item: D4038-041

D4038-041

Parent Item Name: Angle Assy Fwd LH

Start Date: 4/20/2016

Required Date: 5/24/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A NEW ISSUE 10-04-21 JLM VERIFIED BY:EC IPP
Rev:B 11.01.31 as per dwg rev.c DD verified by:ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4038-1		Manufactured	No			100	Each	0.0000	1	1			
D4038-1									**				DAS 6 9-89
Angle, Fwd, LH										144137			
D4038-5		Manufactured	No			100	Each	3.0000	1	1 2			
D4038-5									**				DAS 6 9-89
Block													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST072				3					
				70416				3					
D4038-9		Manufactured	No			100	Each	2.0000	1	1 2			
D4038-9									**				DAS 6 9-89
Block													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				st073				2					
				135003				2					
AN3-14A		Purchased	No			100	Each	97.0000	2	2 4			
AN3-14A									**				DAS 6 9-89
Bolt													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				over003				80		4			
				m133992				50					
				m134360				30					
				ST349				17					
				m134167				17					

MAY 16 2016

Picklist Print

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Page 2

Work Order ID: 144125

144125

Parent Item: D4038-041

D4038-041

Parent Item Name: Angle Assy Fwd LH

Start Date: 4/20/2016

Required Date: 5/24/2016

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

100

Each

2,067.000

2

2

MS21042L3

**

Nut

LocationLoc QtyLoc Code

FP001

100

m133790

100

GA

798

m133790

6

m134360

792

Return2016

1

M132382

1

ST304

1168

m134039

12

m134360

1156

NAS1149D0363J

Purchased

No

100

Each

2,280.000

4

4

NAS1149D0363J

**

Washer

LocationLoc QtyLoc Code

GA

598

m134055

598

Return2016

2

m132317

2

ST260a

1000

m134606

1000

ST263

680

m134370

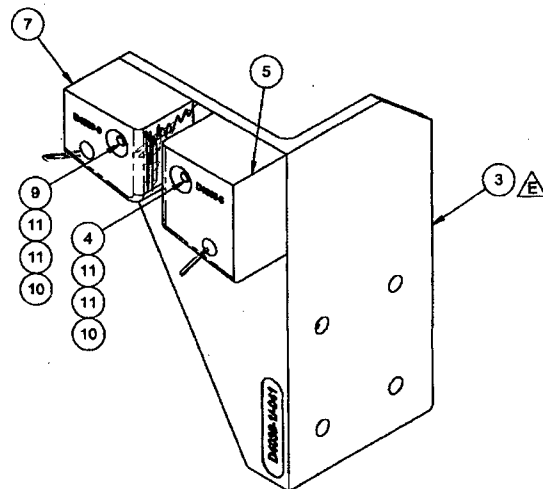
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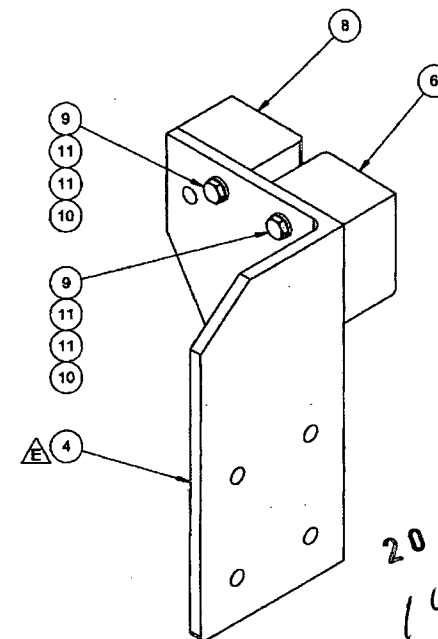
Shop Packet Print

Page 2

ITEM NO.	QTY. -041	QTY. -042	PART NUMBER	DESCRIPTION
1	X		D4038-041	ANGLE ASSEMBLY, FWD, LH
2		X	D4038-042	ANGLE ASSEMBLY, FWD, RH
3	1		D4038-1	ANGLE, FWD, LH
4		1	D4038-2	ANGLE, FWD, RH
5	1		D4038-5	BLOCK
6		1	D4038-6	BLOCK
7	1		D4038-9	BLOCK
8		1	D4038-10	BLOCK
9	2	2	AN3-14A	BOLT
10	2	2	MS21042L3	NUT
11	4	4	NAS1149D0363J	WASHER (AN960JD10)



D4038-041 ANGLE ASSEMBLY, FWD, LH



D4038-042 ANGLE ASSEMBLY, FWD, RH

20160405
1441125
5A

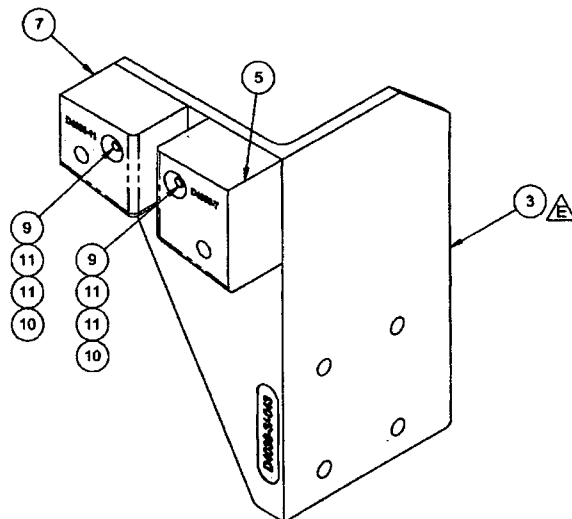
RELEASED
2011-04-31

E	1.18 X 1.00 CHAMFER WAS R1.00. REF: NCR11-543.	MB	11.04.11
D	REVISED D4038-7/8/11-12 AS FOLLOWS: 1.87 WAS 1.73 (C7-9); 2.14 WAS 2.00 (C4-9); 2.13 WAS 2.00 (C7-10); 1.86 WAS 1.73 (C4-10); 1.52 WAS 1.38 (C7-13); 1.78 WAS 1.65 (C4-13); 1.77 WAS 1.65 (C7-14); 1.49 WAS 1.38 (C4-14). REASON: NCR11-456.	MB	11.03.03
C	REVISED D4038-3/4 AS FOLLOWS: 0.589 WAS 0.714 (B2-5, B4-6); D4038-043/044 ARE AFFECTED. REASON: NCR11-399.	MB	11.01.20
B	REVISED DIMENSIONS ALL SHEETS, ADD Ø0.316 HOLES IN -1/2-3/4 PARTS, ADD RADIUS TO -1/2-3/4 PARTS	HS	10.01.05
A	NEW ISSUE	HS	08.12.14
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.04.11		
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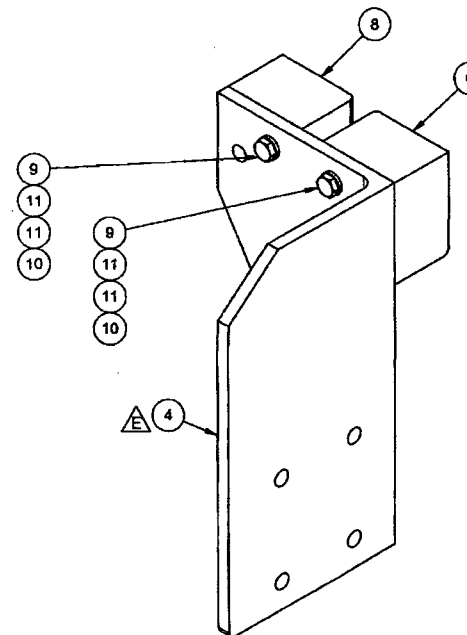
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: -041 - 1.75 lbs
-042 - 1.74 lbs

ITEM NO.	QTY. -043	QTY. -044	PART NUMBER	DESCRIPTION
1	X		D4038-043	ANGLE ASSEMBLY, AFT, LH
2		X	D4038-044	ANGLE ASSEMBLY, AFT, RH
3	1		D4038-3	ANGLE, AFT, LH
4		1	D4038-4	ANGLE, AFT, RH
5	1		D4038-7	BLOCK
6		1	D4038-8	BLOCK
7	1		D4038-11	BLOCK
8		1	D4038-12	BLOCK
9	2	2	AN3-14A	BOLT
10	2	2	MS21042L3	NUT
11	4	4	NAS1149D036J	WASHER (AN960JD10)



D4038-043 ANGLE ASSEMBLY, AFT, LH



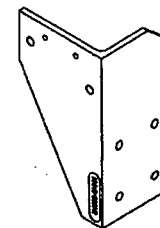
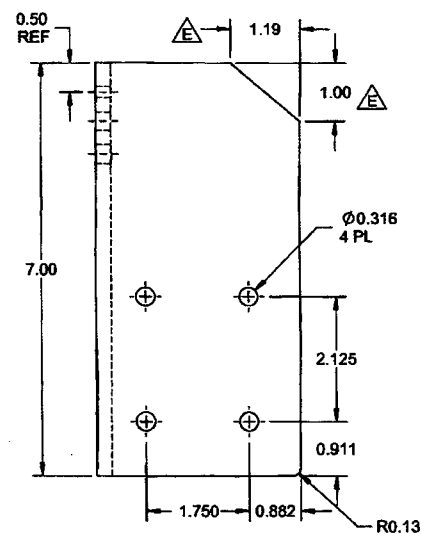
D4038-044 ANGLE ASSEMBLY, AFT, RH

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: -043 - 1.96 lbs
-044 - 1.74 lbs

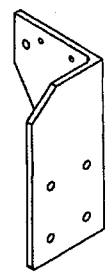
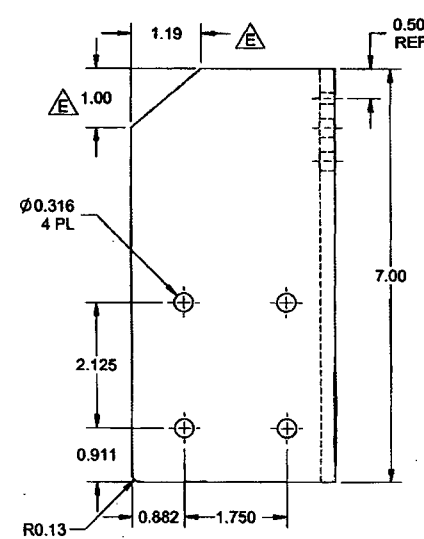
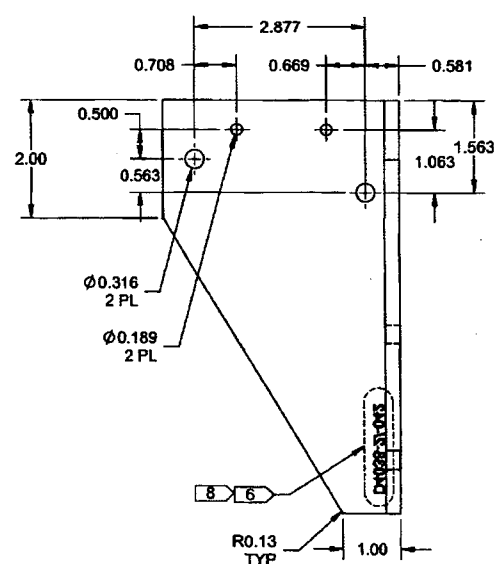
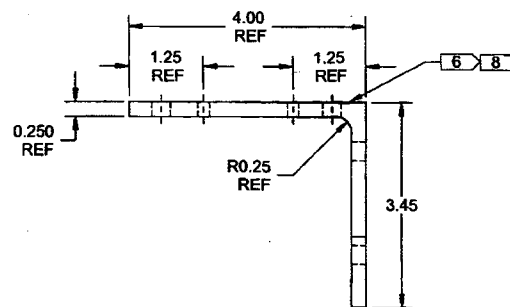
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2011-04-21



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2011-04-21

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APPROVED			
DE APPR.			
DATE	11.04.11		



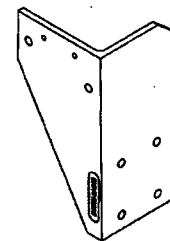
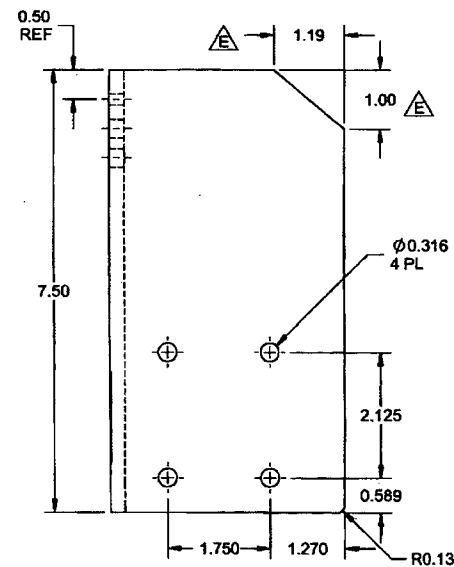
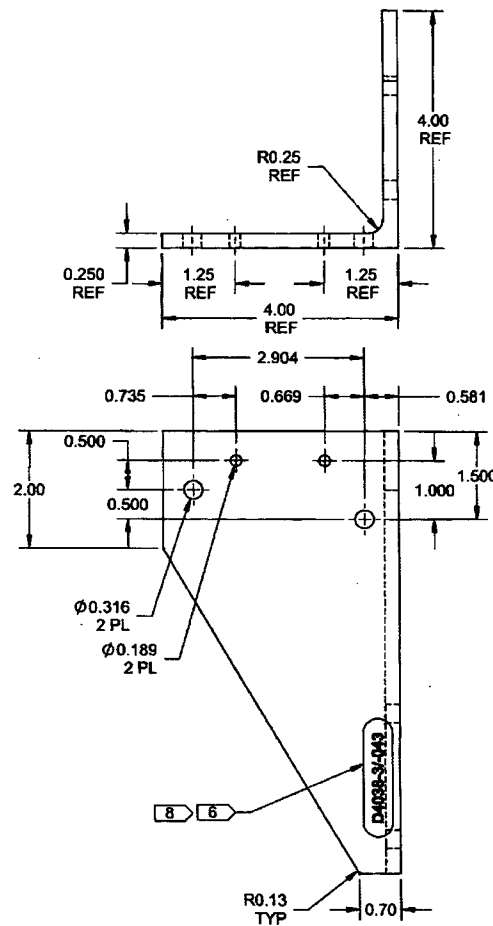
D4038-2 ANGLE, FWD. RH

NOTES:

- 1) MATERIAL: 6061-T6/T6510/T6511 ALUMINUM ANGLE, 4.000 X 4.000 X 0.250
PER AMS-QQ-A-200/8
REF DART SPEC M6061T6A4.000XW250
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE P/N IN THIS AREA AS SHOWN (FAR SIDE ONLY) TO MAX
DEPTH OF 0.010 IN 0.18 HIGH LETTERS WITH MIN RADIUS TOOL OF 0.015
- 7) WEIGHT: 1.03 lbs
- 8) SPOT FACE MAX DEPTH OF 0.010 PRIOR TO MARKING

RELEASED
2011-04-20

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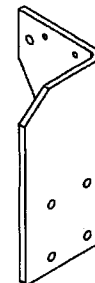
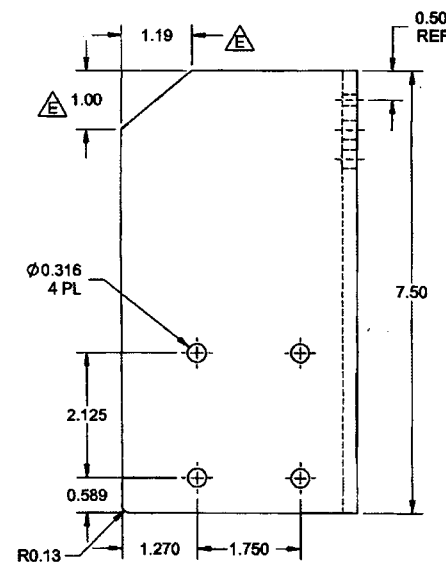
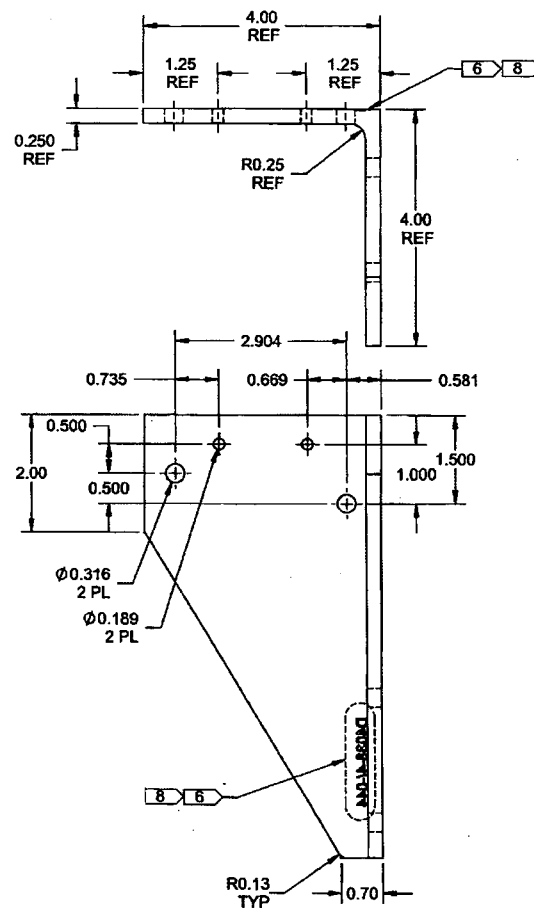
NOTES:

- 1) MATERIAL: 6061-T6/T6510/T6511 ALUMINUM ANGLE, 4.000 X 4.000 X 0.250
PER AMS-QQ-A-200/8
REF DART SPEC M6061T6A4.000XW250
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE P/N IN THIS AREA AS SHOWN (NEAR SIDE ONLY) TO MAX
DEPTH OF 0.010 IN 0.18 HIGH LETTERS WITH MIN RADIUS TOOL OF 0.015
- 7) WEIGHT: 1.18 lbs
- 8) SPOT FACE MAX DEPTH OF 0.010 PRIOR TO MARKING

D4038-3 ANGLE, AFT. LH

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
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2011-06-21
JMT



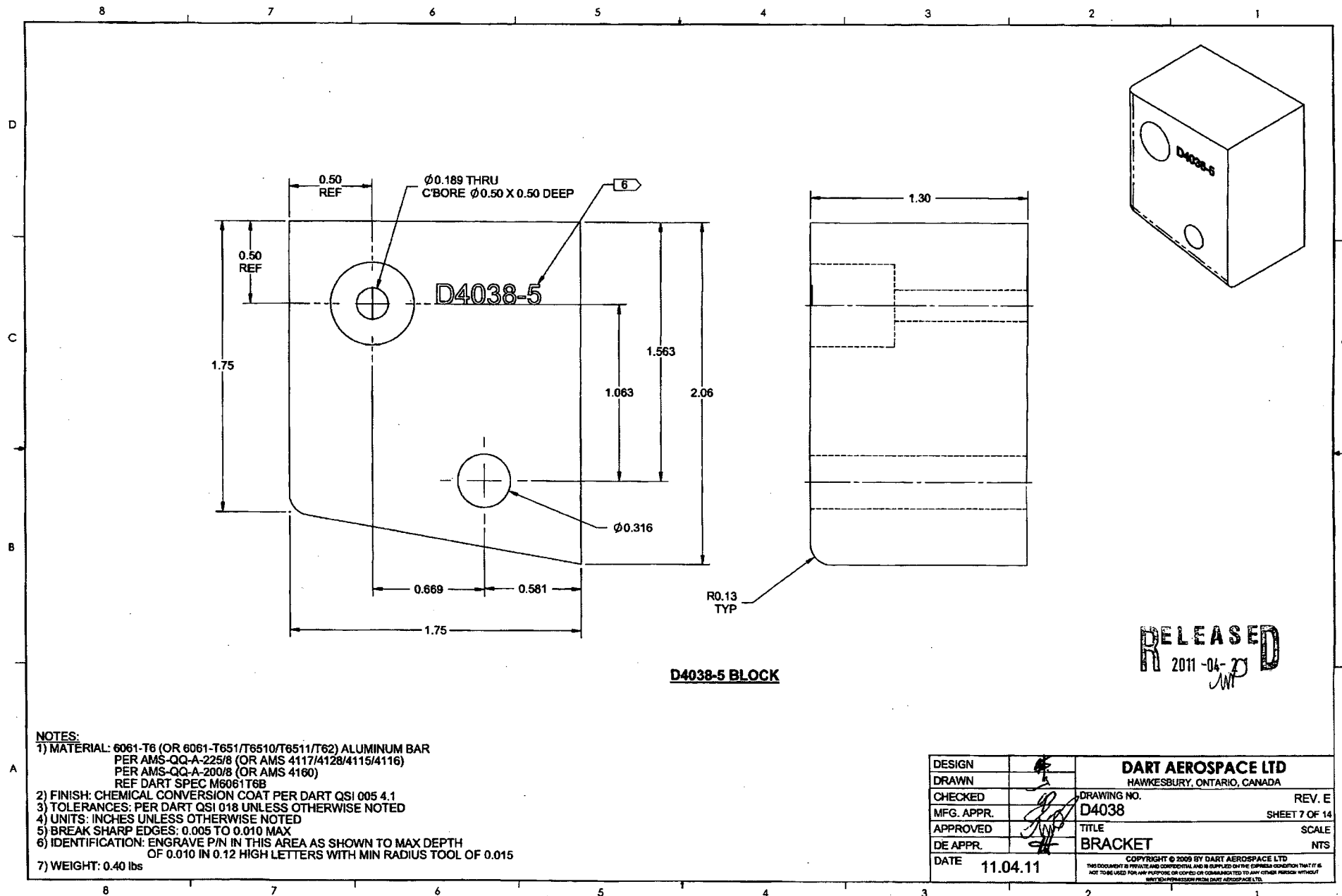
D4038-4 ANGLE, AFT, RH

NOTES:

- 1) MATERIAL: 6061-T6/T6510/T6511 ALUMINUM ANGLE, 4.000 X 4.000 X 0.250
PER AMS-QQ-A-200/8
REF DART SPEC M6061T6A4.000XW250
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE P/N IN THIS AREA AS SHOWN (FAR SIDE ONLY) TO MAX
DEPTH OF 0.010 IN 0.18 HIGH LETTERS WITH MIN RADIUS TOOL OF 0.015
- 7) WEIGHT: 1.18 lbs
- 8) SPOT FACE MAX DEPTH OF 0.010 PRIOR TO MARKING

RELEASED
2011-05-21

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
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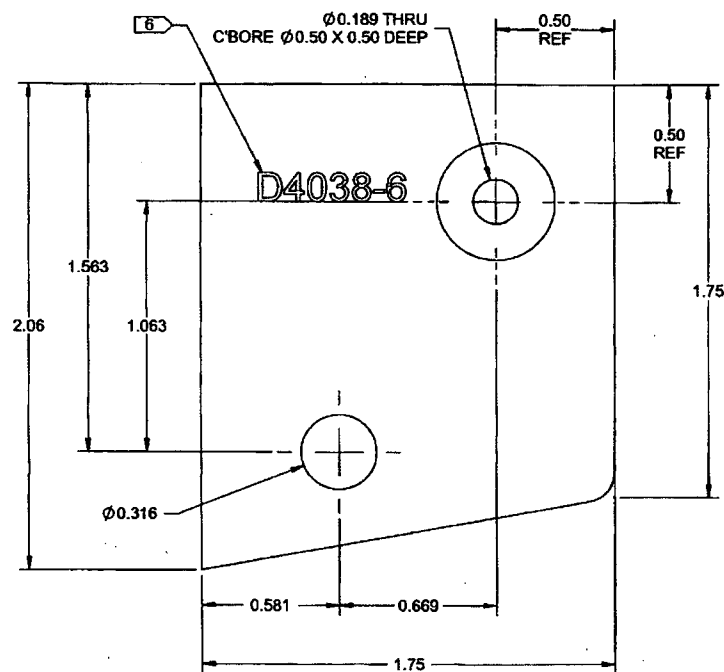


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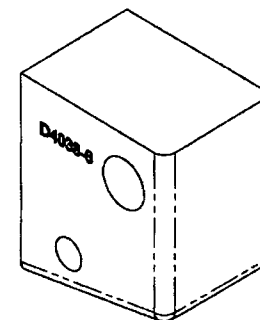
D

C

B



D4038-6 BLOCK



D

C

B

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
PER AMS-QQ-A-200/8 (OR AMS 4160)
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE P/N IN THIS AREA AS SHOWN TO MAX DEPTH
OF 0.010 IN 0.12 HIGH LETTERS WITH MIN RADIUS TOOL OF 0.015
- 7) WEIGHT: 0.40 lbs

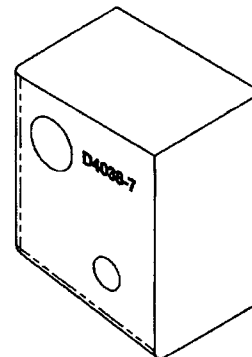
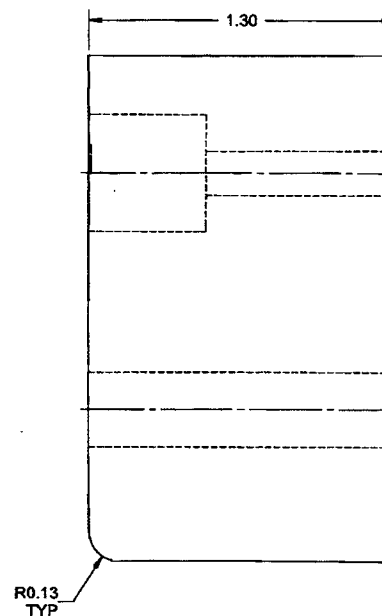
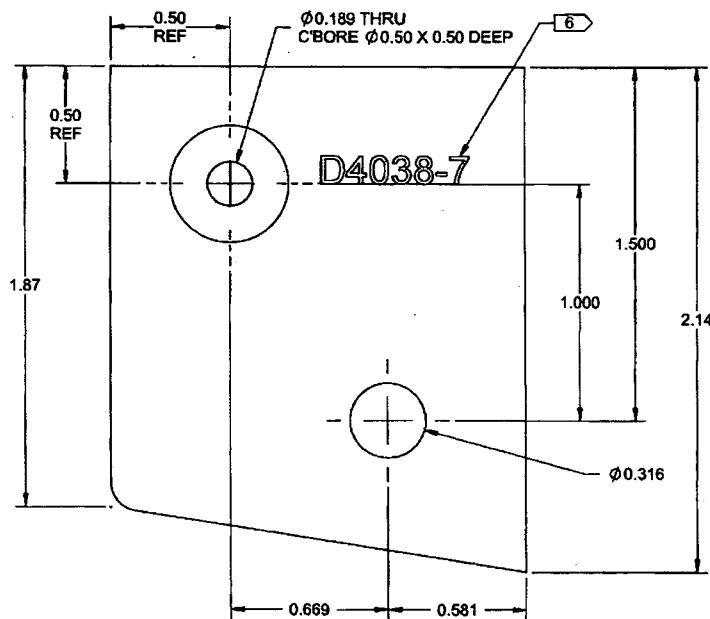
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D4038	REV. E
MFG. APPR.		TITLE BRACKET	SHEET 8 OF 14
APPROVED			SCALE
DE APPR.			NTS
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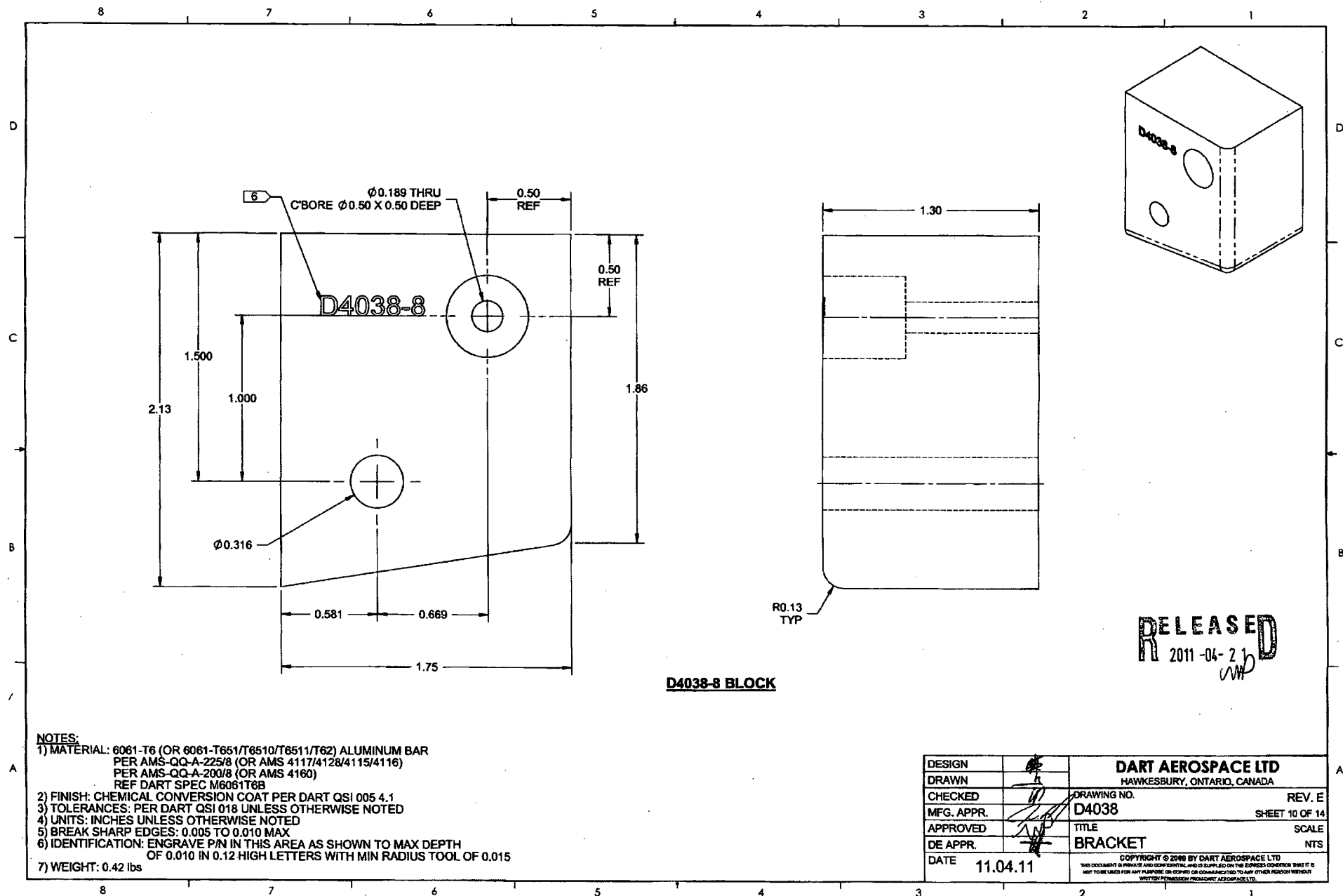
D4038-7 BLOCK

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NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6511/T62) ALUMINUM BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
PER AMS-QQ-A-200/8 (OR AMS 4160)
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE P/N IN THIS AREA AS SHOWN TO MAX DEPTH
OF 0.010 IN 0.12 HIGH LETTERS WITH MIN RADIUS TOOL OF 0.015
- 7) WEIGHT: 0.42 lbs

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